

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016689**Date Inspected:** 01-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Huang min / Mr. Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06551.

Magnetic Particle Testing (MT)

This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Side plate weld Components. Total number of welds MT Tested: 14 No's. The weld designations are review as follows:

1. SP3133-001-038,039,066,067
2. SP3141-001-124,125,166,167
3. SP3141A-001-058,059,100,101
4. SP3123-001-016,017

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Signed off the following green tags.

1. 14510 ~ 14513.

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint CB3002C-018-004. Welder is identified as 205386. ZPMC Quality Control (QC) is identified as Mr. Zhang Zhi Wei. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2231-B-U2-F.

FCAW of weld joint W2-SB5-001-204,205. Welder is identified as 062447. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

ZPMC Personnel performing weld back gouging of weld joint identified as CB3002-018-001. Refer the attached photos for reference.

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Shielded Metal Arc Welding (SMAW) Tack welding of weld joint DP3179-001-005,006. Welder is identified as 049771. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112-FCM.

FCAW of weld joint SP3145A-001-032,033. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Xu hai yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint SP3145A-001-028,029. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Xu hai yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint SP3131-001-027,028. Welder is identified as 205386. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint SP3131-001-049,050. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint SP3131-001-035,036. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

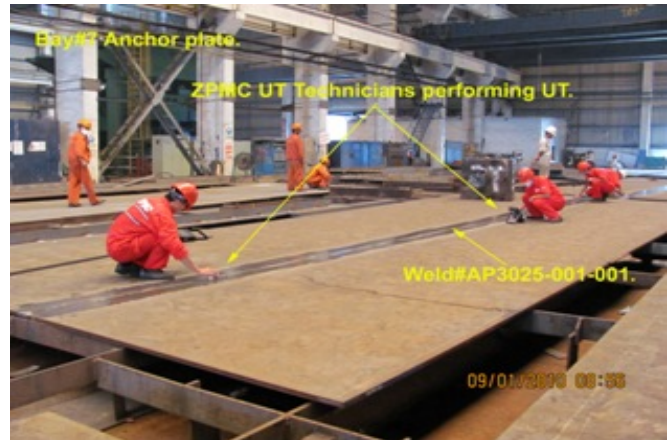
ZPMC UT Technicians performing Ultrasonic Testing for the Anchor plate splice weld joint identified as

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AP3025-001-001.Refer the attached photos for reference.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Prabhu,Surendra | Quality Assurance Inspector |
| Reviewed By: | Hall,Steven | QA Reviewer |
